

## ABSTRACT

A method of machining a work in a numerically controlled lathe is provided which is capable of reducing 5 the machining cost by shortening idle time at the time of switching and which is capable of enhancing the lifetime by lessening a load on a feeding mechanism of a tool rest.

After completion of the machining of a work W with a tool T1 on one tool rest (13), the one tool rest (13) is 10 moved to a standby position B and, at the same time, the other tool rest (15) is moved from a standby position D and the feed speed of the other tool rest (15) is controlled such that the one and the other tool rests (13, 15) simultaneously reach positions C and F preset between the 15 work W and the standby positions B and D.